

Date: Tuesday, 23/09/2008 1:00:01 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 42249	
Estimate Number : 12736 /	
P.O. Number :	Part Number : D353515
This Issue : 23/09/2008 S.O. No. :	Drawing Number : D3535 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 42233	Material :
Written By :	Due Date : 05/10/2008 Qty: 12 Um: Each
Checked & Approved By : <u>JLM 08.9.23</u>	
Comment : Est Rev:A New Issue 07-02-15 JLM	
Est Rev:B As per Rev B 07-08-31 JLM	Verified By:EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
-----	-----------	--------------------



Comment: Qty.: 1.0715 sf(s)/Unit Total: 12.8583 sf(s)
 304/316 .040 Sheet
 (M304S20GA)
 Batch: 109088 IB 8-11-5

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3535
 Dwg Rev: B
 Prog Rev: B IB 8-11-5
 2-Deburr if necessary IB 8-11-5

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

S 22/11/05

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326
 2-Form joggle as per Dwg D3535 using Jig DT8158
 3-Identify as D3535-15

EB 08/11/11 (13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 23/09/2008 1:00:01 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 42249

Part Number: D353515

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 08/11/12 (13)

7.0

POWDER COATING

POWDER COATING



M106442



(13X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

11:20

OVEN TEMPERATURE:

320 °F

FINISH TIME:

11:30

M-L 08/11/13

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/11/13 (13)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-18

FL 08/11/13 (13)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/14

Job Completion



MX-08-11-13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	42249
Description: Wearshoe		Part Number:	D3535-15
Inspection Dwg: D3535 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.888	X			
2.000	+/-0.010	2.002	X			
5.650	+/-0.010	5.650	X			
9.150	+/-0.010	9.150	X			
14.400	+/-0.010	14.400	X			
19.650	+/-0.010	19.650	X			
24.900	+/-0.010	24.900	X			
30.150	+/-0.010	30.150	X			
33.650	+/-0.010	33.650	X			
35.650	+/-0.010	35.650	X			
39.150	+/-0.010	39.150	X			
Ø0.188	+0.005/-0.001	.190	X			
24.00	+/-0.030	24.00	X			
16.00	+/-0.030	16.00	X			
8.00	+/-0.030	8.00	X			
5.00	+/-0.030	5.00	X			
0.300	+/-0.010	.304	X			
0.300	+/-0.010	.306	X			
0.038	+/-0.010	.035	X			

Measured by:	RB	Audited by:	S	Prototype Approval:	N/A
Date:	8-11-5	Date:	08/11/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	E

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

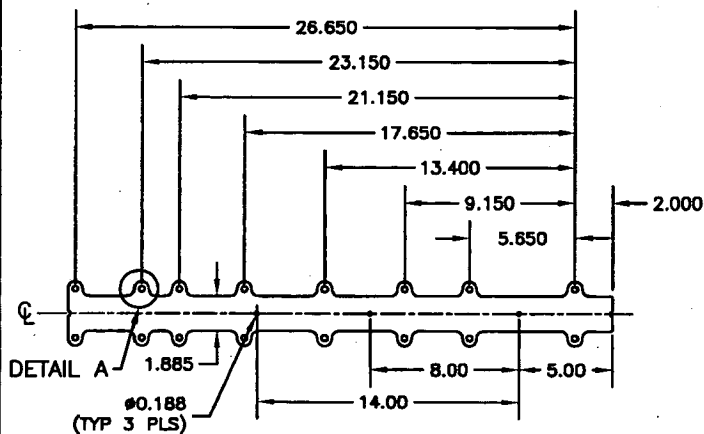
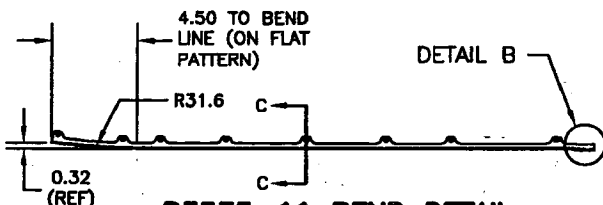
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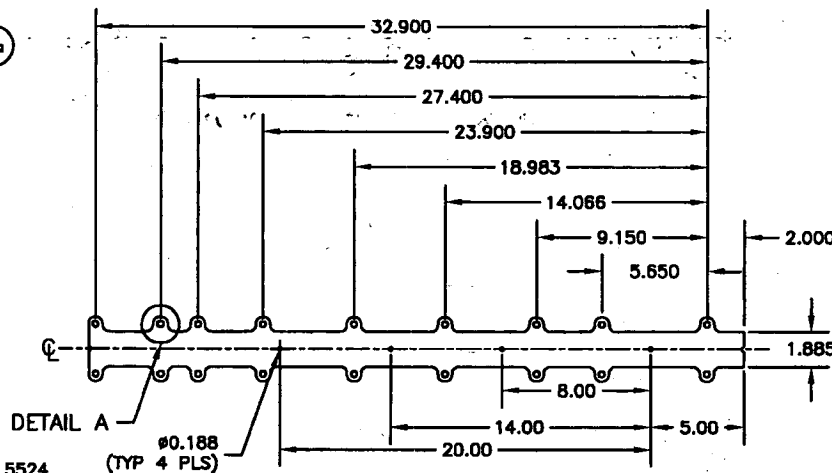
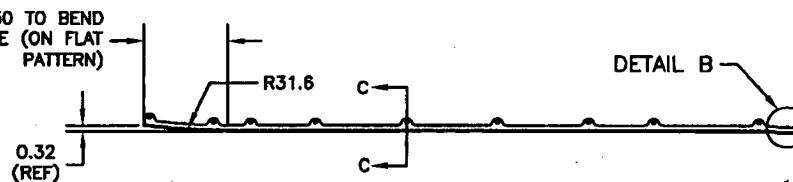
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07.04.24

**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL**

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WITHOUT NOTICE
WORK ORDER
NO. 122017

**D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	AM	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 1 OF 7
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

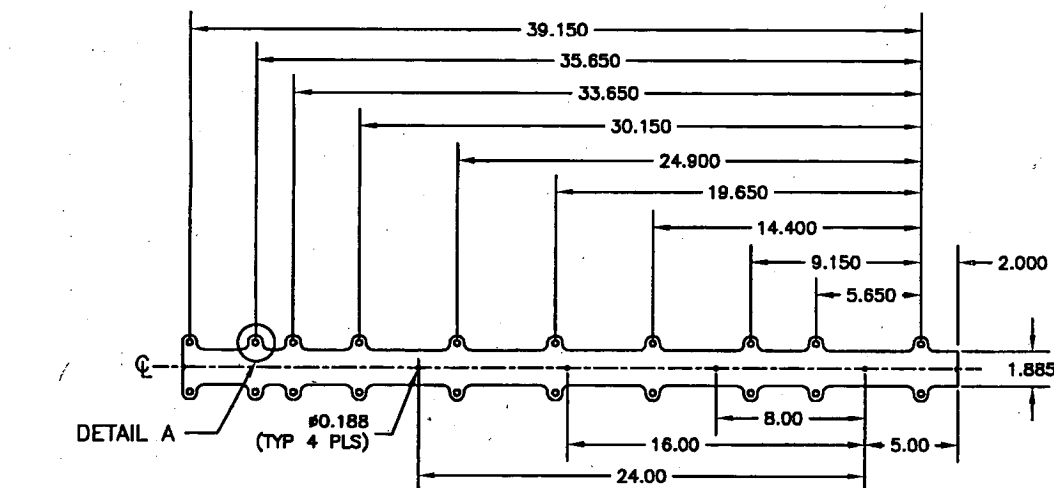
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07.04.17

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		TITLE	WEARSHOE	SHEET 2 OF 7
		SCALE	1:10	

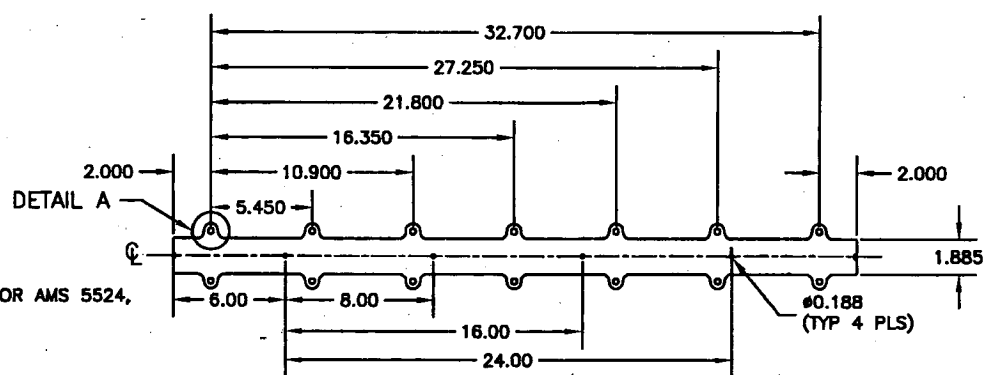
**D3535-15F FLAT PATTERN**4.50 TO BEND
LINE (ON FLAT
PATTERN)0.32
(REF)**D3535-15 BEND DETAIL**

DETAIL B

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NOTES

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**D3535-21F FLAT PATTERN**

DETAIL B

D3535-21 BEND DETAIL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

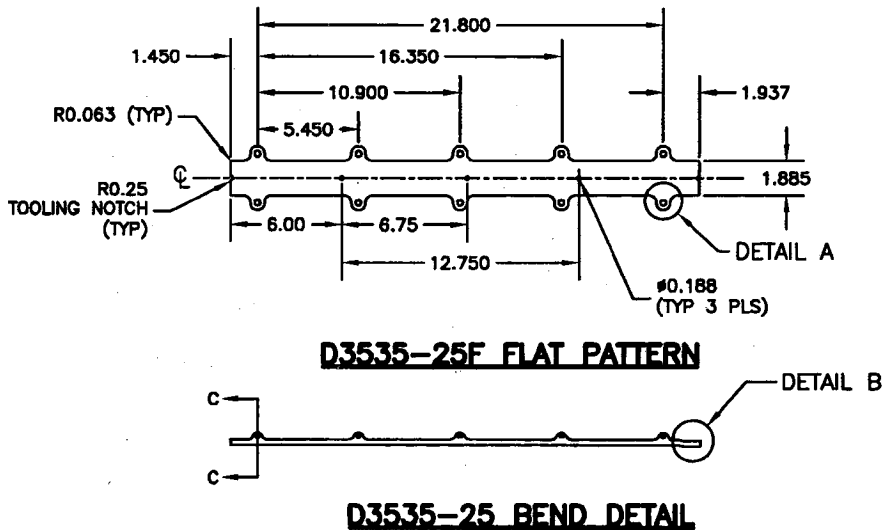
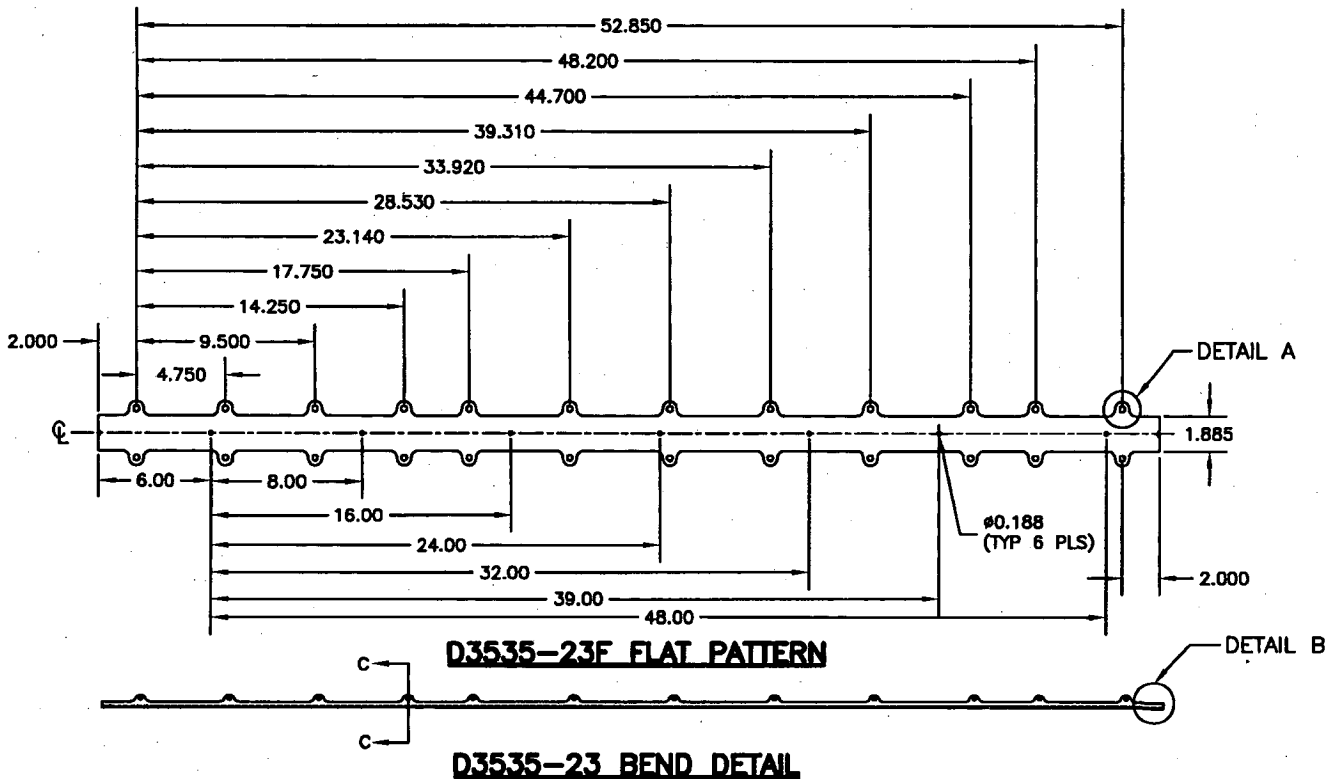
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DATE 07.04.17	TITLE WEARSHOE		SCALE 1:10

07-04-24



- NOTES**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,
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QSI 005 4.3
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OTHERWISE NOTED
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PAINT MARKER
 - 8) SEE PAGE 7 FOR DETAILS AND SECTION

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NO. 229 WORK ORDER

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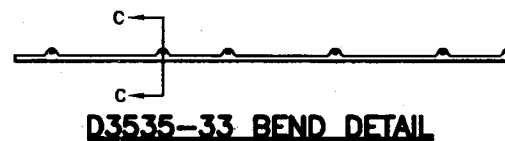
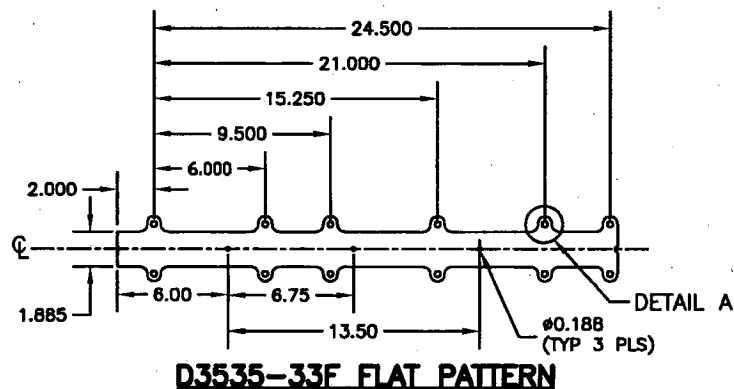
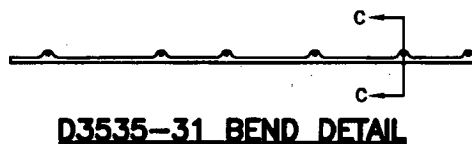
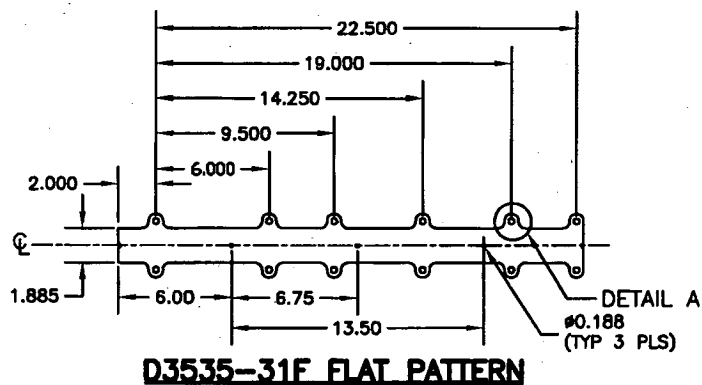
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NO. 42249

NOTES

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(REF DART SPEC M304S20GA)
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CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 4 OF 7
				SCALE 1:10

W/O:		WORK ORDER CHANGES						
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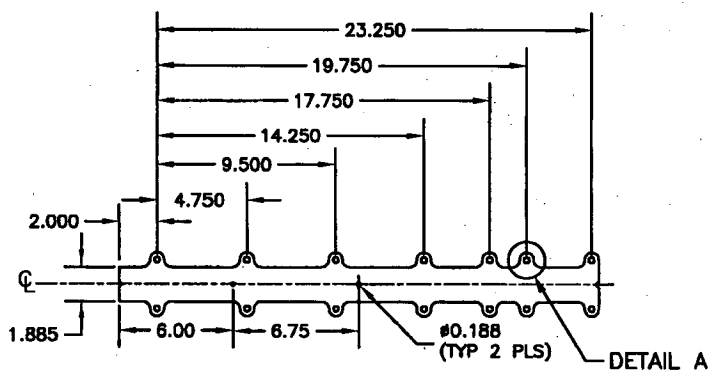
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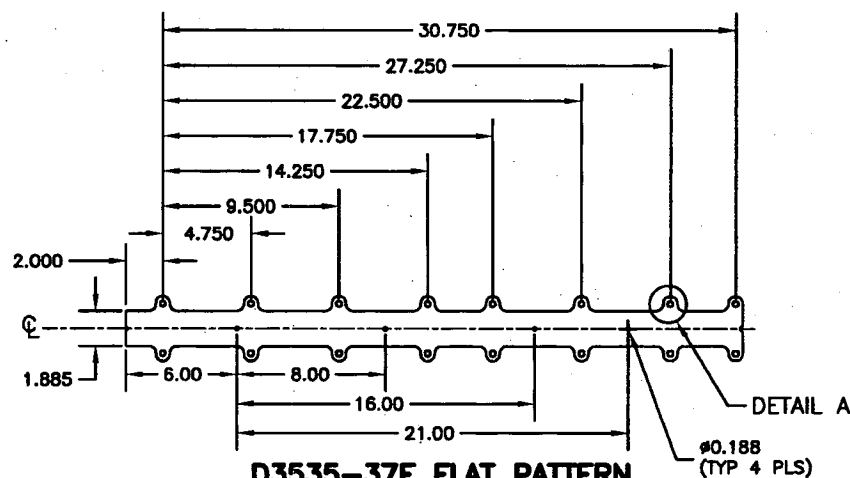
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3535	SHEET 5 OF 7
DATE	TITLE	WEARSHOE	SCALE
07.04.17			1:10



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

NOTES

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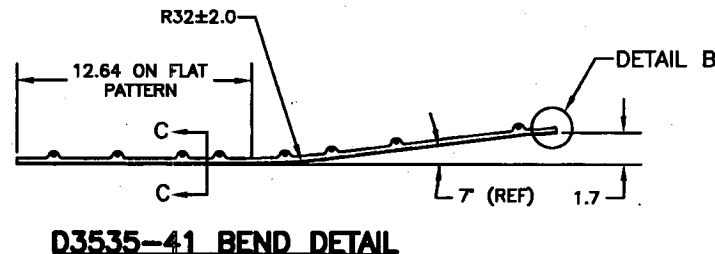
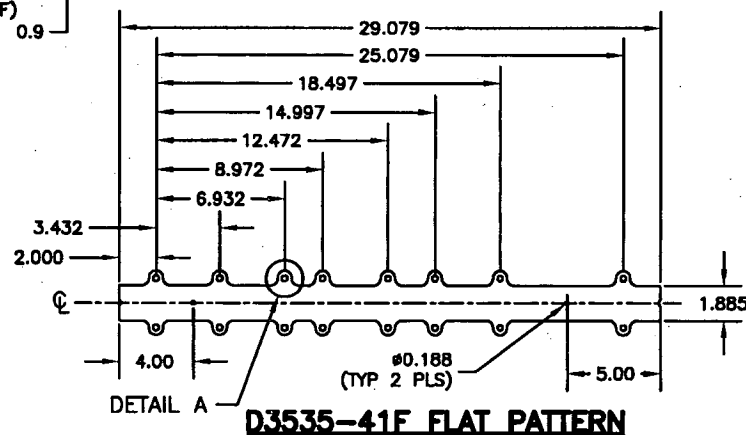
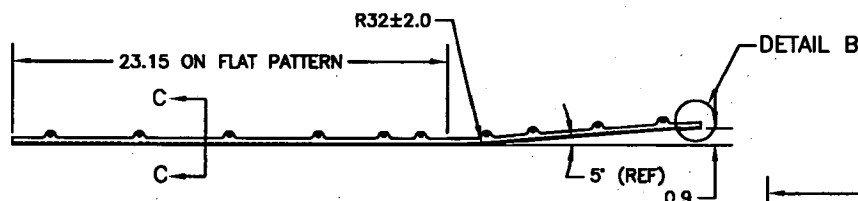
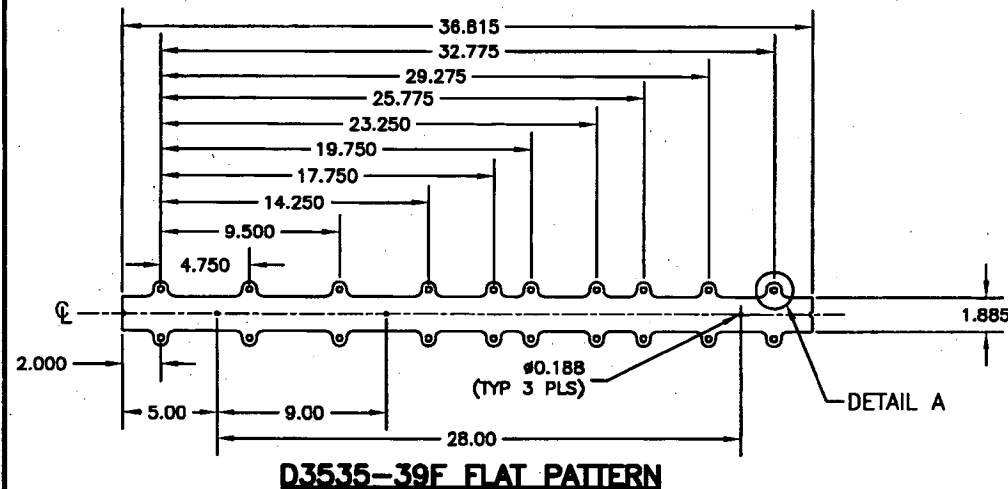
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 6 OF 7
		SCALE 1:10

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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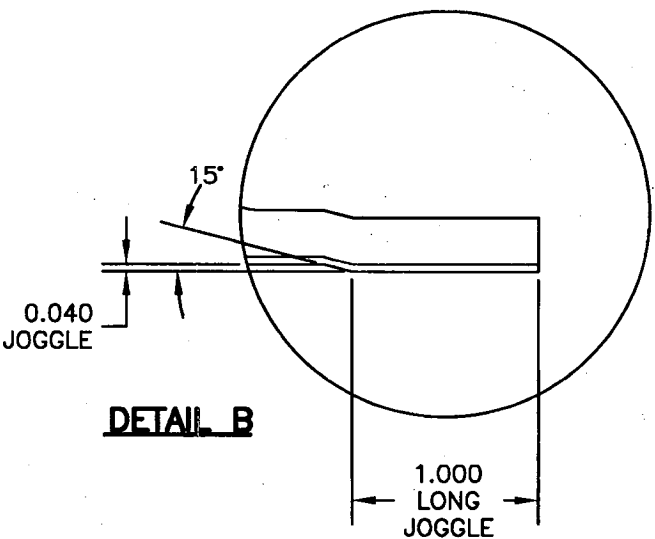
NOTE: Date & initial all entries

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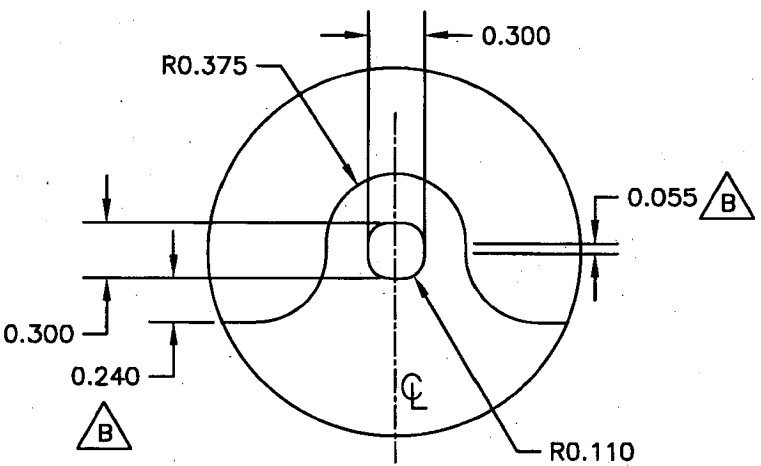
DESIGN	C.B.	DRAWN BY	MH	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 7 OF 7
		SCALE	1:1	

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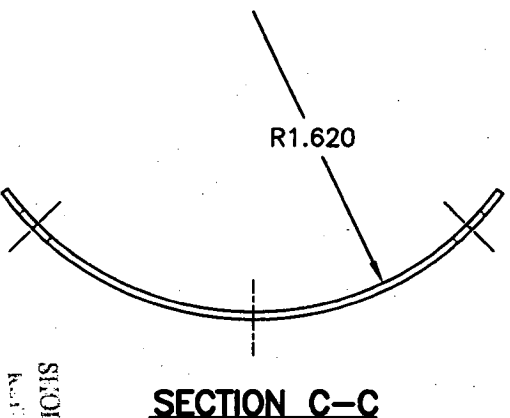
07.04.24



DETAIL B



DETAIL A



SECTION C-C

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11/20/99

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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